


Date: Wednesday, 2/20/2008 4:20:28 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : REMOVABLE HELI UTILITY STEP RH
 Job Number : 37519
 Estimate Number : 13195
 P.O. Number : Part Number : D205541048
 This Issue : 2/20/2008 S.O. No. : Drawing Number : IIN D205-541 REV G *U/R*
 Prsh Rev. : NC Project Number :
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : G
 Previous Run : 37518 Material :
 Written By : Due Date : 3/14/2008 Qty.  1 Um: Each
 Checked & Approved By :
 Comment : Est Rev: A new issue 08-02-19 verified by: LL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD205-541-048 CHG001

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D3724042 Step Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Step Assy *37533*

4.0 D37311 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 PLATE *B37124*

5.0 D3736041 PLATE ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 PLATE ASSEMBLY *B37126*

6.0 D37511 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Shim *B37486*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REMOVABLE HELI UTILITY STEP RH

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Part Number: D205541048

Job Number: 

Seq. #: Machine Or Operation: Description:

7.0 AN313A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Bolt M104746

JS 08/03/17 (XU)

8.0 AN314A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Bolt M105953

JS 08/03/17 (XU)

9.0 AN960JD10L Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)
Washer M104885

JS 08/03/17 (XU)

10.0 MS21042L3 Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)
Nut M106242

JS 08/03/17 (XU)

11.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS 08-03-17 (1) *plw: kit at later date.*

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-048

Location: _____

PPP Rev: _____

DRAFT *08/03/17*

**ENGINEERING
APPROVAL**

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



37533

EFFECTIVE 08-02-21 AUTH *JS*
RELEASED *JS* DATE 08-03-17

08/03/17
W. Johnston
08/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

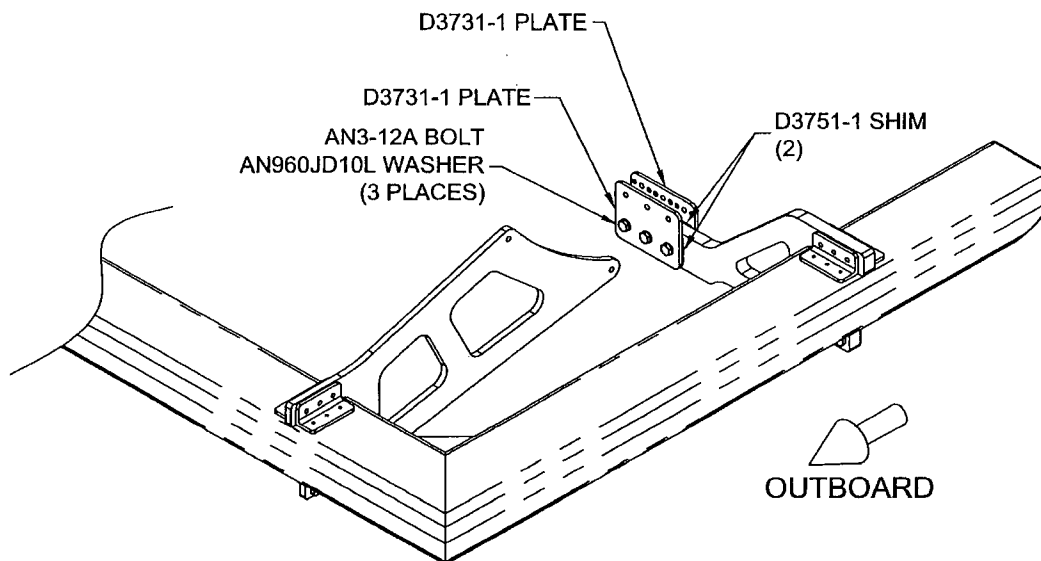


Figure 10 – Step Plate Assembly

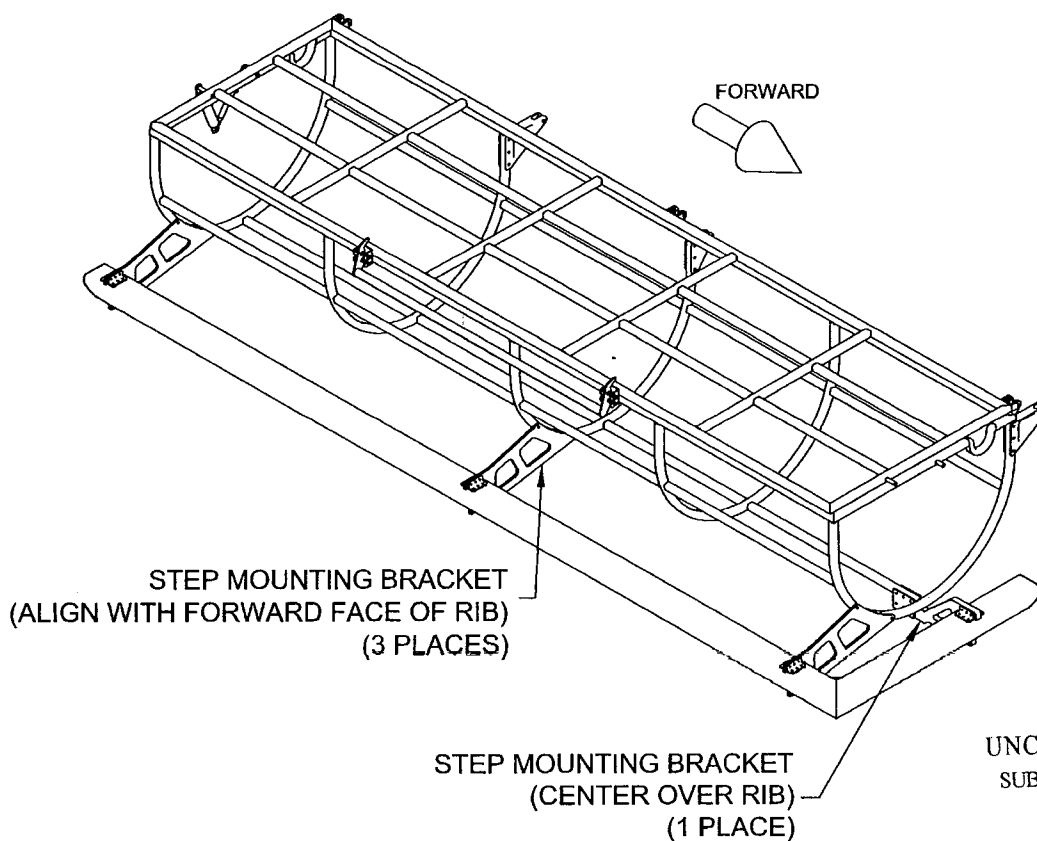
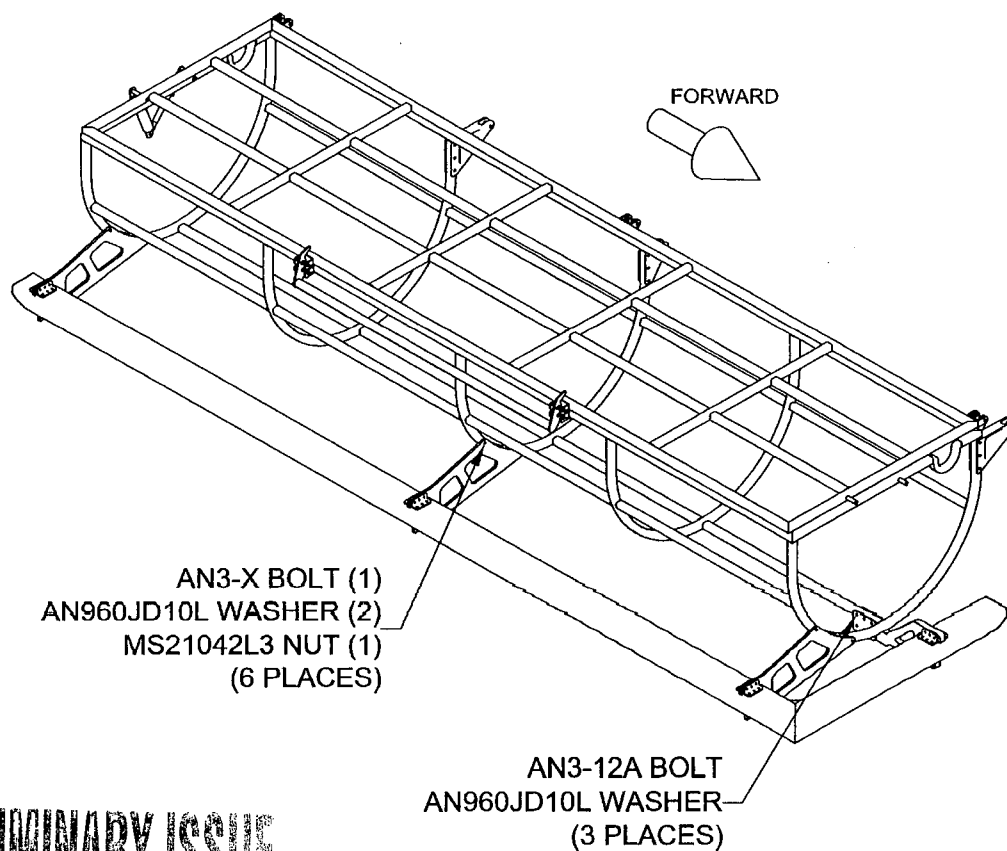


Figure 11 – Step Alignment

PRELIMINARY
NO 5.02.21.08

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WORK ORDER
NO. 375A



PRELIMINARY ISSUE

ASS 02.21.08

Figure 12 – Step Installation

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NO. 37519

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kG	132.25 in 3.36 m	15606 in-lb 180.1 m-kG
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kG	132.25 in 3.36 m	15606 in-lb 180.1 m-kG
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kG	132.25 in 3.36 m	13754 in-lb 158.9 m-kG
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kG	132.25 in 3.36 m	13754 in-lb 158.9 m-kG
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 59.63 in - 1.51 m	- 834 in-lb - 9.7 m-kG	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kG
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 59.63 in + 1.51 m	+ 834 in-lb + 9.7 m-kG	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kG

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Revision: **G**

Date: 08.02.04

...CONTINUED FROM PREVIOUS PAGE

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
2*	2*			MS20600AD4W3	RIVET
2*	2*	2*	2*	MS21042L3	NUT (OR MS21042-3)
4*	4*	5*	5*	MS21042L4	NUT (OR MS21042-4)
16	16	16	16	MS21042L4	NUT (OR MS21042-4)
4*	4*	4*	4*	MS21042L5	NUT (OR MS21042-5)
2	2	2	2	MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

7.0 OPTIONAL EQUIPMENT

Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

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